

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019420**Date Inspected:** 20-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013AP'-086 [Floor Beam (FB) 3188A to Longitudinal Diaphragm (LD) 3034A, Complete Joint Penetration (CJP) weld at Panel Point (PP) 119]. The welder is identified as 067183 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19851 Rev-0.

Repair welding of weld joint no: SEG3013X-206 [FB3186A to Edge Beam (EB) 3031B, CJP weld]. The welder is identified as 067588 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. Liu Feng. The welding variables recorded by this QC appeared to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19927 Rev-0.

The SMAW process on weld joint no: SEG3013E-116 [RS3428E stiffeners on Side Panel (SP) 3090E to FB3198A, CJP weld at PP119.65]. The welder is identified as 066163 and was observed welding in the 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013AX-046 (FB3186A to X4321AD, CJP weld at PP119-1500). The welder is identified as 067876 and was observed welding in the 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13BW and Seg 13CW:

The Submerged Arc Welding (SAW) process on weld joint no: OBW13A-001-016 [Deck Panel (DP) to DP, splice joint, CJP weld]. The welder is identified as 250050 and was observed welding in the 1G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020X-011 (LD to BP, CJP weld at PP125 to 125.5). The welder is identified as 066038 and was observed welding in the 1G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: CWR-2659 Rev-0.

The SMAW process on weld joint no: SEG3020F-063 (LD3051A to FB3337A, CJP weld at PP128]. The welder is identified as 037748 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer